

Ship June 30

Dart Aerospace Ltd.

Date: Thursday, 6/15/2006 1:57:38 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 27535		
Estimate Number	: 10746		
P.O. Number	: NIA	Part Number	: D34633
This Issue	: 6/15/2006 S.O. No. : NIA	Drawing Number	: D3463 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/12/2006 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 25718	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/19/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	10
Comment	: EST REV. A 05.11.18 NEW ISSUE EC	Um:	Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet

Comment: Qty.: 0.2430 sf(s)/Unit Total : 0.9720 sf(s)
304/316 .063 Sheet

Batch: M7106

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

SAD 06-06-21

10

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Form dimples as per dwg D3463 using D3463-3T1

FF 06-06-23

10

2-Deburr

FF 06-06-20
06-06-21

4/6

3-Bend as per dwg D3463

SB 06/06/26

(10)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-27 10

~~06-06-20~~

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: NS

06/06/27 (10)

Date: Thursday, 6/15/2006 1:57:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27535

Part Number: D34633

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

⑩
2006/06/27

Job Completion



U 06-06-27

Ship June 30

Dart Aerospace Ltd.

Date: Monday, 6/12/2006 3:49:17 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 27535		
Estimate Number	: 10746		
P.O. Number	:	Part Number	: D34633
This Issue	: 6/12/2006	S.O. No. :	Drawing Number : D3463 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1	Type	: SMALL /MED FAB
Previous Run	: 25718	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 6/19/2006
Comment	: EST REV. A 05.11.18 NEW ISSUE EC	Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34633F Step Flat Pattern



Comment: Qty: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) (M304S166A)

~~Step Flat Pattern~~~~Pick:~~~~Qty Part Number Description Batch~~~~1 D3463-3F step flat pattern~~.063" 304 SS SHEET.
Batch: M7106

SAD 06:06:20 4

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form dimples as per dwg D3463 using D3463-3T1

2-Deburr

3-Bend as per dwg D3463

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

1.2 WATERJET DWG REV: B
PRG REV: B

1.3 QC2

1.4 QCS Second Check.

SAD 06:06:22

06.06.22 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-20								

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *RS* Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:49:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27535

Part Number: D34633

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/06/27

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

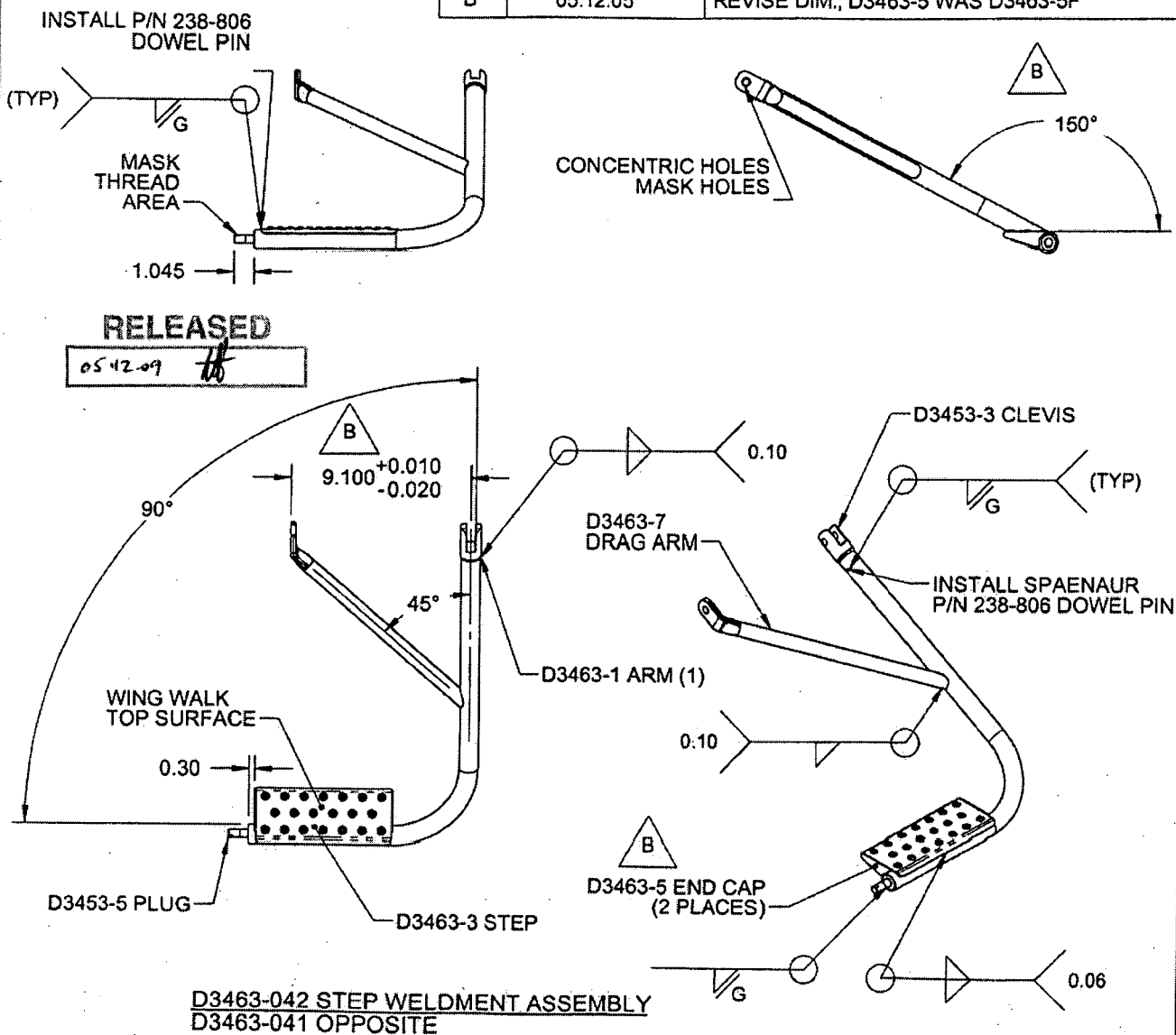
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

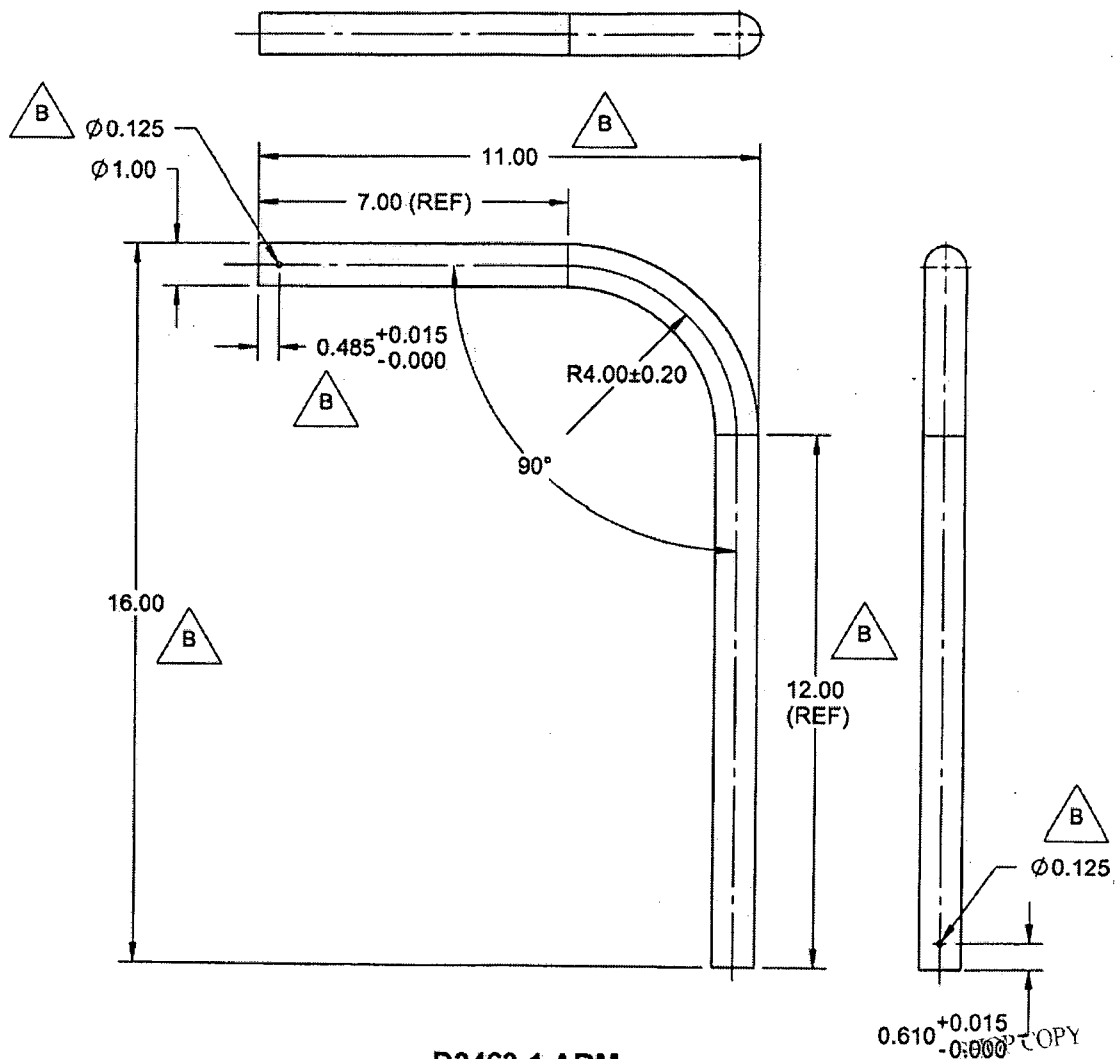
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NO. **21535**

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR11000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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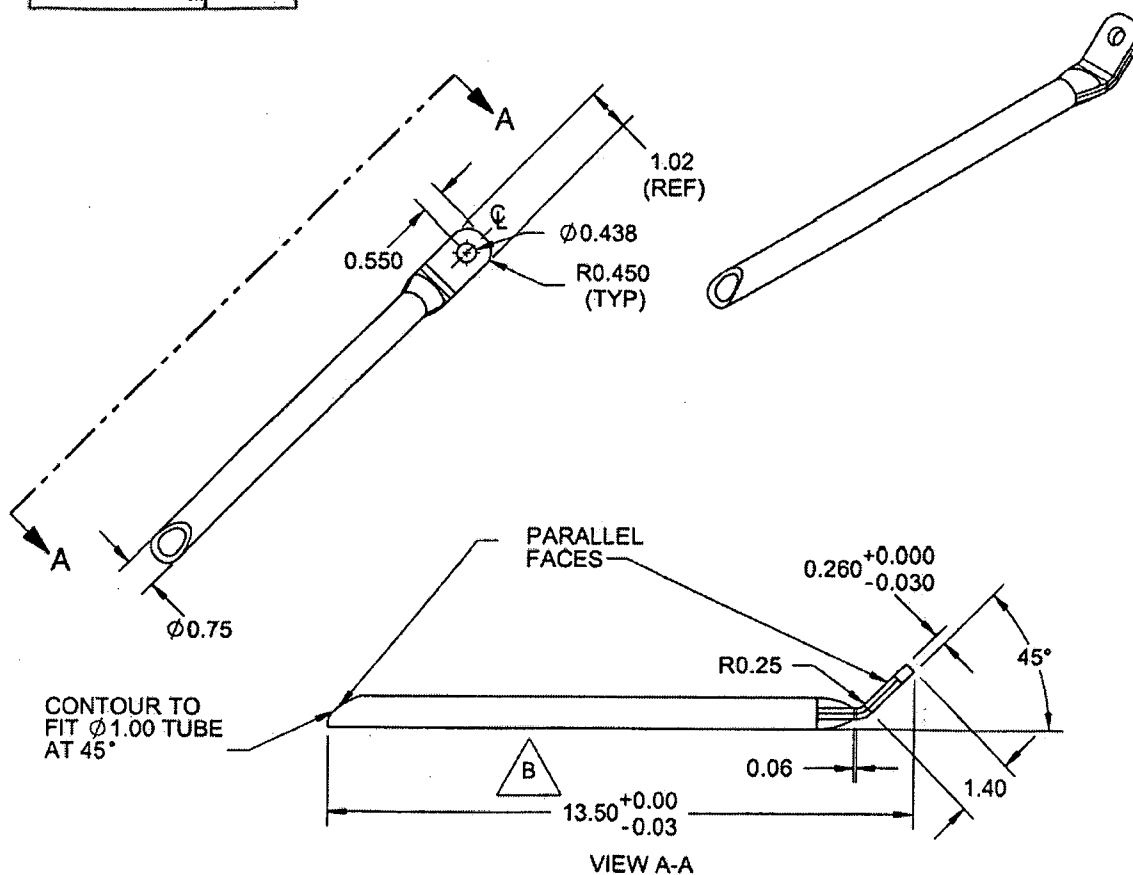
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CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 #



D3463-7 DRAG ARM

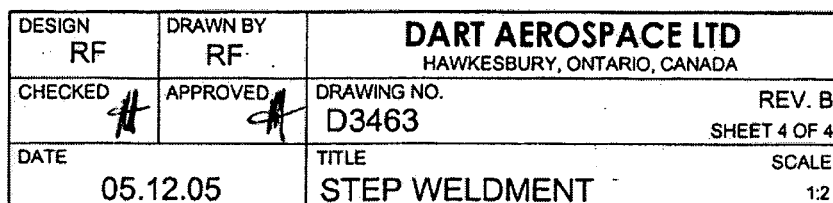
NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W-120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

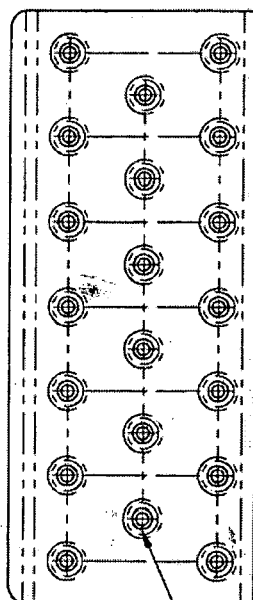
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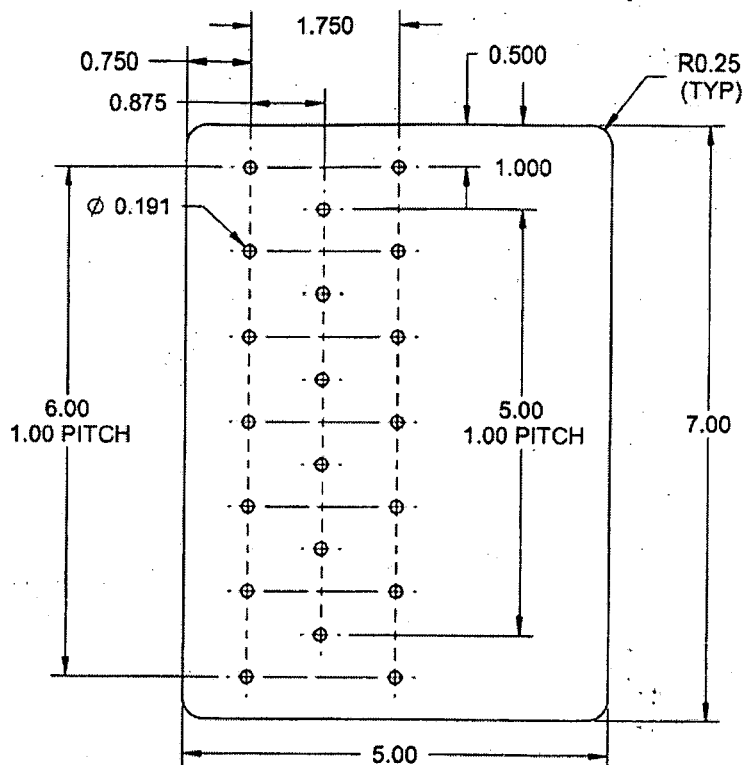
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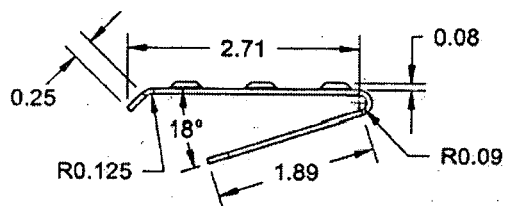
05.12.09



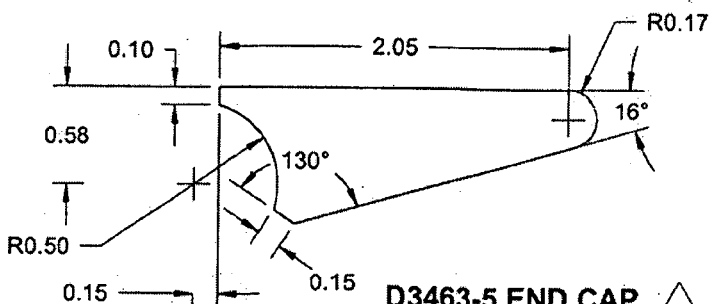
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1

1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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